



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2724-041
Job Sheet 185561



Part No: D2724-041

Job Qty: 2 ea

Part Name: 206L Step Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:E As Per Ecn 766 06-01-06 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/16/18	0.00	0.00	Start Up Large Fab-4		CC
100	Large Fab	2 pcs		11/16/18	0.00	3.08	Large Fab 8		CC
105	QC	2 pcs		11/16/18	0.00	0.00	QC5		CPL
110	Large Fab	2 pcs		11/16/18	0.00	3.08	Large Fab 2		CC
120	QC	2 pcs		11/16/18	0.00	0.00	QC9		SH
130	QC	2 pcs		11/16/18	0.00	0.00	QC5		SH
140	HandFinish	2 pcs		11/16/18	0.00	0.54	HandFinish1		D.R 18/11/06
150	QC	2 pcs		11/16/18	0.00	0.00	QC7-1		CPL
160	Large Fab	2 pcs		11/16/18	0.00	3.08	Large Fab 2		DAS
170	QC	2 pcs		11/16/18	0.00	0.00	QC10		38 DAS
180	QC	2 pcs		11/16/18	0.00	0.00	QC5		9-80 38
190	HandFinish	2 pcs		11/16/18	0.00	0.54	HandFinish1		D.R 18/11/16
200	Powdercoat	2 pcs		11/16/18	0.00	0.32	Powdercoat1		BE 18-11-16
210	QC	2 pcs		11/16/18	0.00	0.00	QC3		38
220	HandFinish	2 pcs		11/16/18	0.00	0.54	HandFinish3		BE 18-11-16
230	QC	2 pcs		11/16/18	0.00	0.00	QC3		NOV 14 2018 68
240	Packaging	2 pcs		11/16/18	0.00	0.00	Packaging3-1		NOV 20 2018 9-89
250	QC21-SA	2 Ea		11/16/18	0.00	0.00	QC21		DAS

Part Op 100 - Cut D2724-1 using D2622 extrusion as per Dwg D2724 Deburr and bevel ends for welding
Descriptions: 110 - Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT10063 A/R AL ROD

Batch:

160 - 1- DRILL AND C'SINK HOLE BEFORE WELDING AS PER DWG(DEO) 2- Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2724 using A/R AL ROD Batch: 3- Grind per dwg D2724 4-

INSTALL RIVET AFTER WELDING

200 - START TIME: 10:35 TEMP: 320° FINISH: 11:05

250 - drill vent hole as per section a-a Weld Remaining end cap as per Dwg D2724 using BLOCK VENT HOLE USING RIVET AS PER DWG

Wing walk 508200M 138963

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 Ea (1 ea)	90-Start up Operation	5104007
D2734	Step End Plate	2 Ea (1 ea)	110-Large Fab	5077383
D3458-1	Step Mounting Plate	4 Ea (2 ea)	110-Large Fab	5002258
D3458-3	Step Mounting Plate	4 Ea (2 ea)	110-Large Fab	5073846

MS20601-AD4W2 → 5124700 → 2x Plex 10/30/18 11:50 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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MS20601-AD4W2
D2734

Rivet
Step End Plate

2 Ea (1 ea)
2 Ea (1 ea)

110-Large Fab
160-Large Fab

83539

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	2	104	0
110-Large Fab	D2734	2	36	0
	D3458-1	4	8	0
	D3458-3	4	11	0
	MS20601-AD4W2	2	159	0
160-Large Fab	D2734	2	36	0

Part Specifications

Specifications could not be found.

Plex 10/30/18 11:50 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

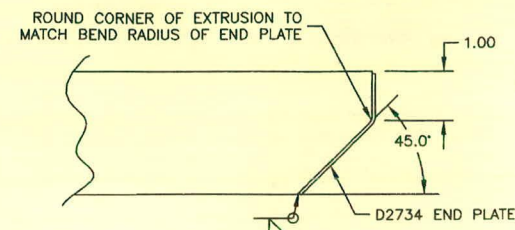
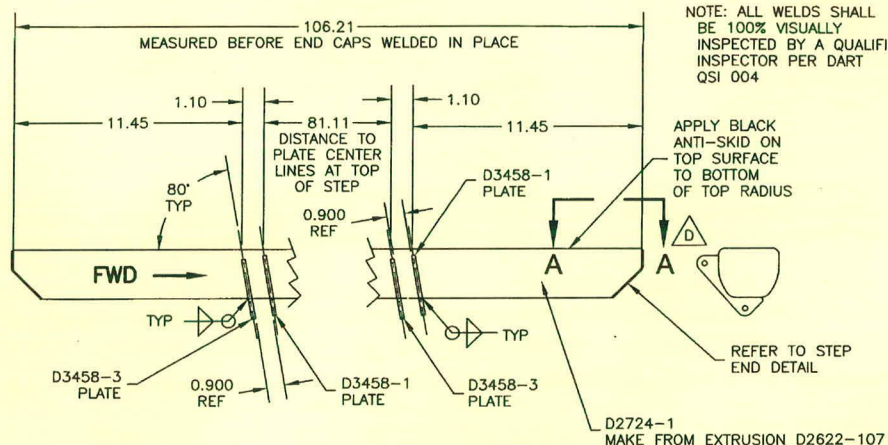
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

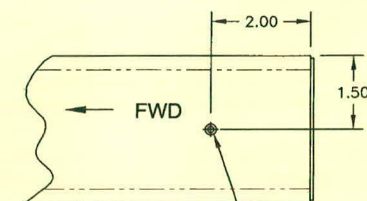
Work Order update only ☐

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Qty -041	Qty -042	Part Number	Description
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE
1	1	MS20601AD4W2	RIVET



TYPICAL STEP END DETAIL
NOT TO SCALE



Ø0.129, CSK Ø0.225 x 100'
OPTIONAL VENT HOLE FOR WELDING
LOCATE ON THIS SURFACE
PLUG WITH MS20601AD4W2 RIVET
AFTER WELDING PRIOR TO FINISH

SECTION A-A
NOT TO SCALE

D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

NOTES:

- 1) MATERIAL: MAKE FROM EXTRUSION D2622
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2724-041/-042" USING FINE POINT PERMANENT INK MARKER PER QSI 044 6.1
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

RELEASED
2016-08-02
Ecn 16-020

D	ADD VENT HOLE REF. 14-355 (ZN C2-1) FORMATTED TO CURRENT STANDARD	RF	16.04.25
C	RE-DESIGN, ADD D3458-1/-3	PH	05.09.19
B	UPDATED WELD DETAIL REVISE TOLERANCES	PH	98.10.19
A	NEW ISSUE	KE	97.12.04
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. D
MFG. APPR.	DD	D2724	SHEET 1 OF 1
APPROVED	DS	TITLE	SCALE
DE APPR.		206/407 STEP ASSEMBLY	NTS
DATE	16.04.25	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

